

Date: Tuesday, 1/3/2006 4:15:06 PM
User: Kim Johnston

Process Sheet

SLIP

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 25354 - 2
Estimate Number : 10035
P.O. Number : NIA
This Issue : 1/3/2006 S.O. No. : NIA
Prsht Rev. : NC
First Issue : NIA Type : MACHINED PARTS
Previous Run : 25353
Written By : SEE COMMENT BELOW
Checked & Approved By :
Comment : Est. A: 01.05.04 New Issue EC

Drawing Name : SADDLE BILLET
Part Number : D6101007
Drawing Number : D6101 REV A
Project Number : N/A
Drawing Revision : A
Material : NIA
Due Date : 7/15/2006 Qty: 100 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 PG PURCHASING



Comment: PURCHASING

Issue P/O: 00000339

06/01/04

a) Description: Alluminum billet

b) 7.750" x 8.250" x 2.50" thick

c) Tolerance on all dimensions are +0.030"/-0.000"

d) Grain direction along 7.750" length

e) Material: 7075-T7351 (QQ-A-250/12)

f) Material certification required

2.0 D6101007 7075-T7351 8.25X7.75X2.5



Comment: Qty.: 1.0000 Each(s)/Unit Total : 100.0000 Each(s)
7075-T7351 8.25X7.75X2.5

3.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure material certification is attached

4.0 QC6 DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

Ensure Material certification comply to Dwg D6101

P.D. 06/07/14 (60)

86 06.07.17 60

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: Date: 06/07/24

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 1/3/2006 4:15:06 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE BILLET

Job Number: 25354

Part Number: D6101007

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: CNC

BK

06-07-17

60

6.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06-07-17

Job Completion



06-07-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

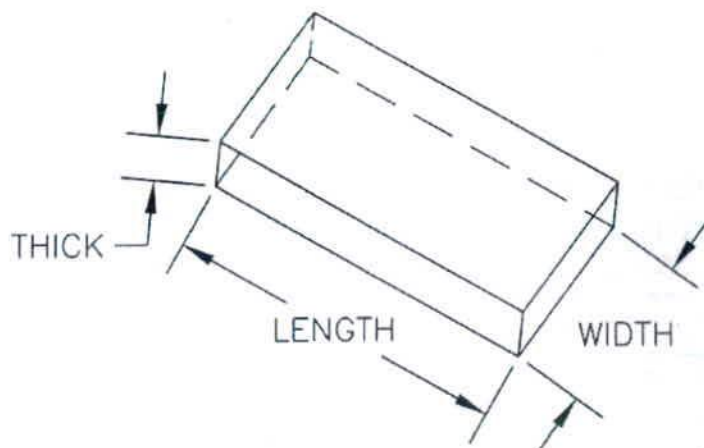
NOTE: Date & initial all entries



DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED S	DRAWING NO. D6101	Rev. A SHEET 1 OF 1
DATE 01.03.30		TITLE SADDLE BILLET, 7075	SCALE NTS
A	01.03.30	NEW ISSUE	

SPECIFICATION CONTROL DRAWING

RELEASED
01.04.23



PURCHASE MATERIAL ACCORDING TO THE FOLLOWING TABLE. SPECIFY ALLOY, LENGTH x WIDTH x THICK (+0.030/-0.000), AND GRAIN DIRECTION AS SHOWN.

TOLERANCES ON ALL DIMENSIONS ARE +0.030/-0.000.

ALL DIMENSIONS ARE IN INCHES.

Part No.	Alloy	Length	Width	Thick	Grain Direction
D6101-001	7075-T7351 (QQ-A-250/12)	6.000	6.250	2.000	Along 6.000 Length
D6101-003	7075-T7351 (QQ-A-250/12)	7.875	6.250	2.000	Along 7.875 Length
D6101-005	7075-T7351 (QQ-A-250/12)	5.000	8.250	2.500	Along 5.000 Length
D6101-007	7075-T7351 (QQ-A-250/12)	7.750	8.250	2.500	Along 7.750 Length
D6101-009	7075-T7351 (QQ-A-250/12)	8.700	8.250	2.500	Along 8.700 Length
D6101-011	7075-T7351 (QQ-A-250/12)	9.700	8.250	2.500	Along 9.700 Length
D6101-013	7075-T7351 (QQ-A-250/12)	10.100	8.250	2.500	Along 10.10 Length

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REQUISITION CLIENT-CUSTOMER REQUISITION NO.		NO. COM. CLIENT-CUST. ORD. NO.		COMPT-ACCT. VEND. SLS TERR. EXPEDIE PAR-SHIP VIA			
		PD 00000339		91037 200 40 CABANO (PPD)			
HETEUR-PURCHASING AGENT		TELEPHONE	H/C TAXE NO. COM ORD	REGION LIVRAISON-DEL ZONE F.A.B.-F.O.B.		BILL	NO. FEVILLE/EMBALLAGE-B/L NUMBER
LINDA LACELLE		613 632-3336	9 0 1 C/C			PREFAID	A105424
/RE A-SHIP TO:		VENDU A-SOLD TO:		INFORMATION CREDIT-CREDIT INFORMATION		ROUTE	
		DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY ON K6A 1K7		R2C SEE FRANCE STATUS		01*-NL-05/0 30-NL-05/1 31-NL-07/1	
INSTRUCTIONS/LIVRAISON-DELIVERY		INSTRUCTIONS LIVRAISON (CONT.)-DELIVERY (CONT'D.)		INSTRUCTIONS LIVRAISON (CONT.)-DELIVERY (CONT'D.)			
INQ-B29602							

DESCRIPTION - ITEM 1		QTE/UNITE COM.-ORDERED		PCES/PO COM.-ORD		POIDS COM.-WT. ORDERED	
2.5000 PLATE 7075-T7351 ALUM 8.25" X 7.75"		60 PCS		PCS		969	
BLACK W/RED STRIPE		BALLOTS-BUNDLES		PCES/PO EXP. SHIP		POIDS EXP.-WT. SHIPPED	
		1		60		969	
CERTIFICATE OF CONFORMANCE		INSTRUCTIONS		COULÉE INFO-HEAT INFO QTE-QTY		FORME-SHAPE I.A.C.	
A.M. Castle & Co. certifies that the material(s) supplied under this document will meet and conform to the specifications of the product(s) described hereon. A.M. Castle & Co. (Canada) Inc.		THICKNESS TOL.: +.030"/- .000" TOL.: +.025"/- .000" SKID: TYPE 3A GRAIN TO RUN ALONG 7.75" ATTN MARTINE: PAS AVANT 13 JUIL		347150 AS		6879	
WEIGHT FOR SHIPPING PURPOSES ONLY. SEE INVOICES FOR ACCURATE BILLING WEIGHT. PLEASE SIGN AND DATE DRIVER'S COPY FOR RECEIPT OF MATERIAL AND, IF CHECKED, TEST REPORTS.		INSTRUCTIONS (CONT'D.)		60 x 8.25" x 7.75"		ENT-W	
						2	

DESCRIPTION - ITEM 2		QTE/UNITE COM.-ORDERED		PCES/PO COM.-ORD		POIDS COM.-WT. ORDERED	
TERMS AND CONDITIONS OF SALE		INSTRUCTIONS		COULÉE INFO-HEAT INFO QTE-QTY		FORME-SHAPE I.A.C.	
SEE DISCLAIMERS AND LIMITATIONS ON THE REVERSE SIDE		1 SKID					
		INSTRUCTIONS (CONT'D.)				ENT-W	

DESCRIPTION - ITEM 3		QTE/UNITE COM.-ORDERED		PCES/PO COM.-ORD		POIDS COM.-WT. ORDERED	
ALL EXCEPTIONS FOR SHORTAGE OR DAMAGE MUST BE NOTED ON THE DRIVER COPY & CUSTOMER COPY OF THE DELIVERY RECEIPTS & SIGNED BY THE DRIVER & CUSTOMER. COPY OF SUCH RECEIPT PROPERLY NOTED MUST BE SUBMITTED WITHIN 10 DAYS WHEN CREDIT IS REQUESTED.		INSTRUCTIONS		COULÉE INFO-HEAT INFO QTE-QTY		FORME-SHAPE I.A.C.	
NOM (LETTRE MOULEE)-NAME (PRINT ONLY)		INSTRUCTIONS (CONT'D.)				ENT-W	
RECU PAR-RECEIVED BY							
DATE RECU-DATE RECEIVED							

FEVILLE D'EMBALLAGE - PACKING SLIP END

04/17/2006 08:04 5099276205

KAISER TRAFFIC

PAGE 13

SHIP TO:
A M CASTLE & CO
3400 NO. WOLF ROAD
FRANKLIN PARK, IL 60131

**KAISER
ALUMINUM**
Trentwood Works - Spokane, WA 99215
Phone: (800) 367-2586

CERTIFIED TEST REPORT

Serial Number
4064596

SOLD TO:
AM CASTLE & CO
3400 NO. WOLF ROAD
FRANKLIN PARK, IL 60131

CUSTOMER PO NUMBER: 01-82185		WORK PACKAGE:	CUSTOMER PART NUMBER: 6879		SHIP RUN/LOAD ID: 100651/13	GOV'T CONTRACT NUMBER: A97075-60
KAISER ORDER NO: 1033617	LINK ITEM: 1	SHIP DATE: 17-APR-2006	ALLOY: 7075	CLAD: BARE	TEMPER: T7351	
WEIGHT SHIPPED: 3612 LB	QUANTITY: 2 PCS EST.	B/L NUMBER: 208101	GUAGE: 2.5000 IN	WIDTH: 48.500 IN	LENGTH: 144.500 IN	

Certified Specifications

AMS 4078/RevF
ASTM B 209/Rev04
BSS 7055/RevA
EAC MS1011/RevA
MMS 159/RevN

AMS-QQ-A-250/12
ASTM-B-594/Rev02
OSTI 006/RevB
GSS16100/RevG
PS 21211/RevJ

AMS-STD-2154
BAC 8439/RevH
DPS 4.713/RevN/AmdA
MIL-STD-2154

Test Code: 4297

Test Results

Lot: 347150A5 Cast 885 Drop 51 Ingot 2

Tensile:	Temper	Dir / # Tests	Ultimate KSI (MPA)	Yield KSI (MPA)	Elongation %
	T7351	LT / 2 (Min:Max)	69.1 : 70.1 (476 : 483)	56.1 : 57.8 (387 : 399)	10.5 : 10.5

Conductivity %IACS :	41.4 Min	41.7 Max
(MS/M) :	24.0 Min	24.2 Max

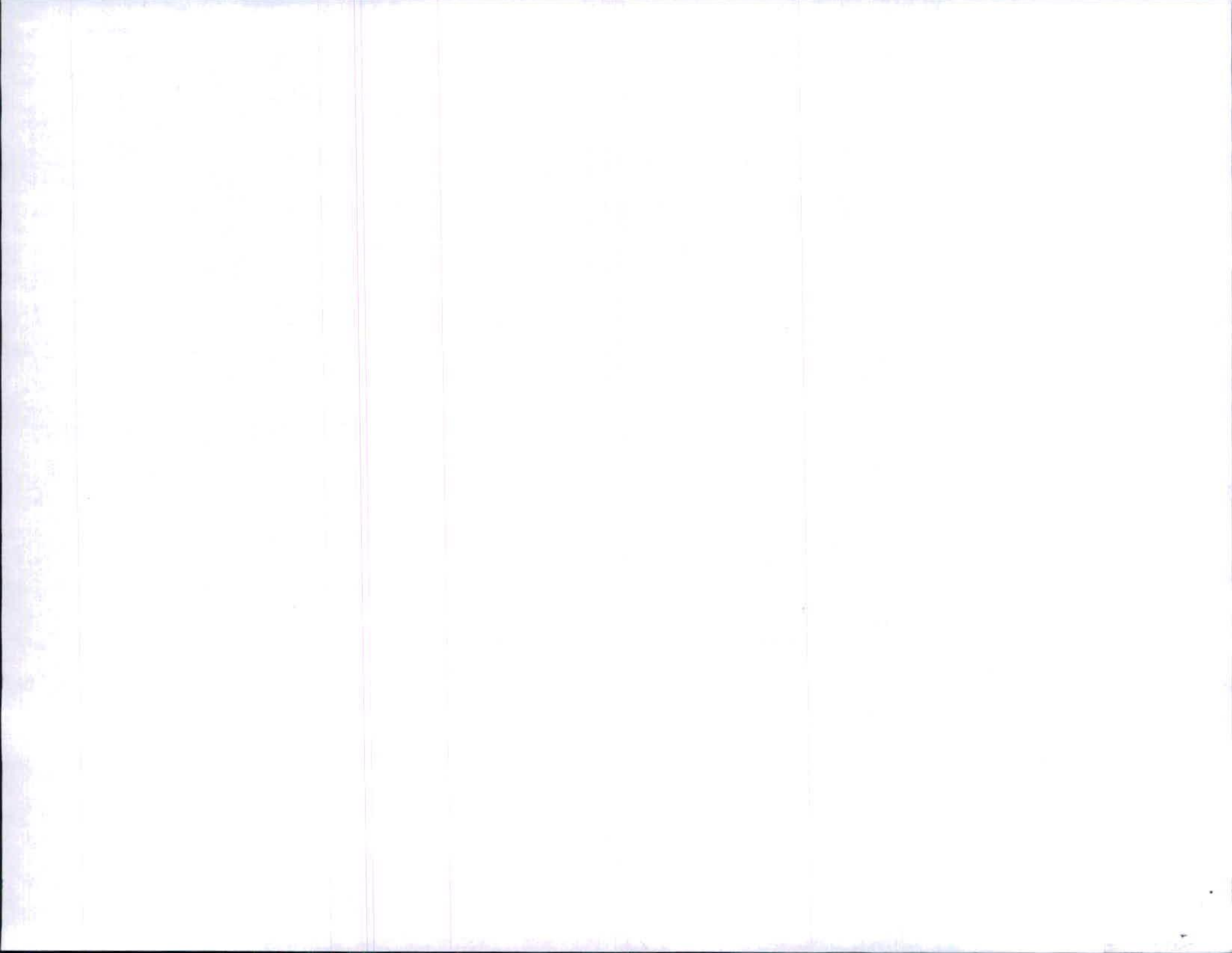
Chemistry:	SI	FE	CU	MN	MG	CR	ZN	TI	V	ZR	OTHER
Actual	0.11	0.25	1.46	0.04	2.49	0.20	5.76	0.03	0.01	0.01	TOT 0.04

ALLOY LIMITS

Chemistry:	SI	FE	CU	MN	MG	CR	ZN	TI	V	ZR	OTHER	MAX
7075 MIN	0.00	0.00	1.20	0.00	2.10	0.18	5.10	0.00	0.00	0.00	EACH	0.05
MAX	0.40	0.50	2.00	0.30	2.90	0.28	6.10	0.20	0.05	0.05	TOT	0.15

Aluminum Remainder

CASTLE METALS FP
DATE REC'D 4.20.06 IAC 6879
APPROVED BY: SW



**KAISER
ALUMINUM**

Trentwood Works - Spokane, WA 99215

Phone: (800) 367-2586

CERTIFIED TEST REPORT

Serial Number

4064596

TEST NOTES

Metal represented by this test report was immersion
ultrasonically tested from one side and meets the Class A
and Class B requirements of all specifications referenced
on this test report.

CERTIFICATION

KAISER ALUMINUM & CHEMICAL CORPORATION (KAISER) HEREBY CERTIFIES THAT METAL SHIPPED UNDER THIS ORDER WAS MELTED AND MANUFACTURED IN THE U.S.A. AND HAS BEEN INSPECTED, TESTED, AND FOUND IN CONFORMANCE WITH THE REQUIREMENTS OF THE APPLICABLE SPECIFICATIONS AS INDICATED HEREIN. A L METAL WHICH IS SOLUTION HEAT-TREATED COMPLIES WITH AMS 2772. ANY WARRANTY IS LIMITED TO THAT SHOWN ON KAISER'S STANDARD GENERAL TERMS AND CONDITIONS OF SALE. TEST REPORTS ARE ON FILE, SUBJECT TO EXAMINATION. TEST REPORTS SHALL NOT BE REPRODUCED EXCEPT IN FULL, WITHOUT THE WRITTEN APPROVAL OF KAISER ALUMINUM & CHEMICAL CORPORATION LABORATORY. THE RECORDING OF FALSE, FICTITIOUS, OR FRAUDULANT STATEMENTS OR ENTRIES ON THE CERTIFICATE MAY BE PUNISHED AS A FELONY UNDER FEDERAL LAW. ISO-9001:2000 CERTIFIED

BILL POYNOR, LABORATORIES SUPERVISOR

